

Work Order ID 107462

107462

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Item ID: D350-600-242 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355
 Start Date: 9/24/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/27/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	F								
DSI9639	A								
IIN D350-600	Rev C								

100 0.00
100 DOCUMENT CONTROL
 DC Memo M. 10. 0.00
 Document Control Photocopy bluefile and type labels as per PPP D350-600-242 CHG001

DAS
06
13/10/14 ✓ MLV

110 0.00
110 Small Fab
 Small Fab Memo 0.00
 Small Fab 1-Drill holes in D3188-2 using drill jig DT8971
 2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188
 3-Deburr
 4-Install inserts in D3188-2 as per Dwg D3188.

1 13.10.01

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/27/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Cut D2986 Neoprene Foam per template D2986T1 2- Adhere D2986 foam to bottom side of D3187-2 spacepod floor using contact adhesive A/R Batch: <u>112983</u>								
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	****This step seperates hardware, previous steps is for body & floor****								

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Item ID: D350-600-242

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/27/13 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Small Fab

0.00

Small Fab

Memo

Small Fab

Assemble D3186-4 door with D3188-2 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y

1-Drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled fibres 10% to weight. Install insert.

A/R Hysol batch: 124484 expire date: 14/01/31 13.10.01

~~A/R Milled fibres batch:~~

2- Prime (grey) as necessary per QSI005

Primer batch: 125894

Hardner batch: 125894

{A} 13-10-3

3-Attach Neoprene Foam to floor using Contact Cement

A/R Contact Cement Batch: 112883

170

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

170

QC

Memo

0.00

Quality Control

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Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13

Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/27/13

Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Wing Walk as per dwg QSI005 4.4 Batch B6506

0.00

180

HandFinish

Memo

0.00

Hand Finishing

Wing Walk Spacepod top surface of Pod as per Dwg D3188

1

W/W 13-10-04

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

①

D310 G4

200

Pick Kit

0.00

200

Packaging

Memo

0.00

Packaging

1X

DAS
28
9-89

13-09-26

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	DAS 06 8-89	13/10/14	(1)				
220 *220* Packaging	Packaging Memo	0.00 0.00	DAS 06 8-89	13/10/17					
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

13-10-07
 ME
 13-10-07

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Work Order ID: 107462

Parent Item: D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A07.03.07 new issue EC
 IPP rev B 07.04.16 reformat, D3188 rev.E EC
 IPP Rev:C 08-09-30 add primer in step 44 DD verified by:EC IPP Rev:D add install insert seq150
 DD 10.03.15 verified by:EC IPP Rev:E remove D3188-2m add D3188-6 DD 10.04.07 verified
 by:JLM IPP REV:F 13.02.06 AS PER
 DSI9639 REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130 Rivnut		Purchased	No			150	Each	2,523.0000	28	28	28	13-09-26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		389							
				119084		116							
				120671		89							
				120807		36							
				120837		8							
				121269		140							
				ST279		40							
				124080		40							
				st510		2094							
				124163		160							
				M126109		1934				28			
AN526C832R10 Screw		Purchased	No			150	Each	119.0000	10	10	10		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST345		119							
				118853		19				10x			
				123831		100							
AN526C832R14 Screw		Purchased	No			150	Each	453.0000	2	2	2		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		453							
				124215		453				2x			

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Parent Item: D350-600-242

Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

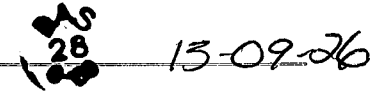
Required Qty: 1.00

AN526C832R24
screw

Purchased No

140 Each 122.0000

4 4



Location

Loc Qty

Loc Code

ST346

122

118870

56

124255

66

4x

AN960JD10

NAS1149D0363J

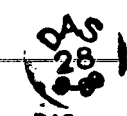
Purchased No

150 Each 0.0000

2 2

WASHER

126319



AN960JD516

NAS1149D0563J

Purchased No

140 Each 2.0000

1 1

Washer

Location

Loc Qty

Loc Code

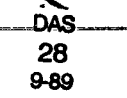
ST504

2

1069059

2

125807



AN960JD8

NAS1149DN832J

Purchased No

140 Each 0.0000

20 20

Washer

126319



D2179

Manufactured No

140 Each 19.0000

2 2

Hinge Bracket Plate

Location

Loc Qty

Loc Code

ST006

19

35432

19

2x



D2228

Manufactured No

150 Each 15.0000

4 4

Backing Plate

Location

Loc Qty

Loc Code

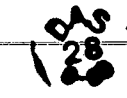
ST007

15

73380

15

4x



D2237

Manufactured No

140 Each 41.0000

2 2

Striker Plate

Location

Loc Qty

Loc Code

ST007

41

102727

7

104470

21

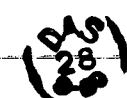
93697

10

96996

3

2x



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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

D2464 Manufactured No
Seal(\$per foot)

150 f 414.8612 10.8 11.368421

13-09-26

Location Loc Qty Loc Code

ST403 414.8611789
61878 83.6406
83543 331.220579

D2585 Manufactured No
Latch Clamp

150 Each 37.0000 2 2

Location Loc Qty Loc Code

ST012 37
101087 22
101805 14
99063 1

2x

D2586 Manufactured No
Door Latch

150 Each 58.0000 2 2

Location Loc Qty Loc Code

FG 13
100607 2
83893 10
95760 1
return2013 3
xxxxx 3
ST203A 42
100607 42

2x

D2621 Manufactured No
Latch Plate

150 Each 22.0000 2 2

Location Loc Qty Loc Code

FG 2
88616 2
ST014 20
88616 20

2x

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Parent Item: D350-600-242

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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

D2857-1 Manufactured No
Hinge Bracket

150 Each 24.0000

1 1

DAS
28
28

13-09-26

Location	Loc Qty	Loc Code
FG	5	
82261	4	
91914	1	
ST019	19	
100965	16	
91914	1	
95859	2	

1x

D2857-2 Manufactured No
Hinge Bracket

150 Each 29.0000

1 1

DAS
28
28

Location	Loc Qty	Loc Code
FG	3	
78904	3	
ST019	26	
100769	24	
95712	2	

1x

D2985 Manufactured No
Label

Each 16.0000

1

DAS
28
28

Location	Loc Qty	Loc Code
ST023	16	
104987	10	
86719	6	

1x

D2985-3 Manufactured No
Decal, RH Install

Each 12.0000

1

DAS
28
28

Location	Loc Qty	Loc Code
ST023	12	
96952	12	

1x

D2986
Black Neoprene 2" X 3"

Manufactured No

140 sf 0.0000

5.62 5.9157895

WHL 13-10-04

99576

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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

D3015-3
Locknut

Manufactured No

130 Each 112.0000 1 1

DAS
28
9-28

13-09-26

Location Loc Qty Loc Code

FG 10
95758 8
96151 2
ST023 102
95758 16
97511 86

D3188-6
Spacepod Body

Manufactured No

110 Each 2.0000 1 1

13-09-24

Location Loc Qty Loc Code

CA 2
75462 1
95202 1

D350-600-449
Switch Relocation

Manufactured No

200 Each 1.0000 1 1

94572

8

Location Loc Qty Loc Code

FG125 1
94572 1

D3538-1
Hinge Bracket

Manufactured No

140 Each 12.0000 2 2

DAS
28
9-28

Location Loc Qty Loc Code

FG 8
84630 1
91834 1
94499 2
98281 4
ST056 4
84630 1
98281 3

B105999

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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

D3554-7
Ball Stud

Manufactured No

140 Each 43.0000 1 1

DAS 28 13-09-26

Location	Loc Qty	Loc Code
FG	5	
87039	5	
ST056	38	
87039	8	
87571	30	

IX

D3557-1
Bracket

Manufactured No

150 Each 12.0000 1 1

DAS 28

Location	Loc Qty	Loc Code
ST058	12	
73384	12	

IX

D3567-2
Decal

Manufactured No

140 Each 13.0000 1 1

DAS 28

Location	Loc Qty	Loc Code
ST058	13	
50375	13	

IX

K10021
Spacepod Hardware (-241)

Manufactured No

200 Each 3.0000 1 1

105759 8

Location	Loc Qty	Loc Code
FG125	1	
93820	1	
ST	2	
105759	2	

DAS 06 8-89

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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5
RIVET

Purchased No

140 Each 2,150.0000 4 4

DA
28
13-09-26

Location

Loc Qty

Loc Code

GA 5
6874 5
ST317 1145
6874 1145
ST334 1000
m125807 1000

4x

MS21042L08
Nut

Purchased No

150 Each 2,808.0000 18 18

DA
28
13-09-26

Location

Loc Qty

Loc Code

ST315 808
122141 3
122452 9
122814 500
123900 296
ST505 2000
125445 2000

18x

Picklist Print

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Work Order ID: 107462

Parent Item: D350-600-242


Parent Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No 150 Each 5,902.0000 2 2  13-09-26

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	3	
122141	3	
GA	18	
122452	18	
ST314	304	
111668	1	
117885	32	
119017	55	
119075	138	
123265	43	
M126036	35	
ST506	1235	
123900	856	
124291	379	
ST510a	4342	
M126275	342	2X
M126333	4000	

MS27039-08-11

Purchased No

150 Each 770.0000

2 2

SCREW

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST307	660	
122441	100	
123352	500	
123900	60	
ST308	110	
125654	110	2X

MS27039-1-15

Purchased No

150 Each 808.0000

2 2

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST506	808	
124326	808	2X

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Start Date: 9/24/13

Required Date: 9/27/13

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

150

Each

225.0000

2

2

Washer

DAJ
28
13-09-26

Location

Loc Qty

Loc Code

FG

4

123301

10

GA

3

124859

3

ST297

208

123301

7

125654

201

2x

• D3186-4

Manufactured

No

110

Each

1.0000

1

1

Spacepod Door, RH

DAJ
28
28

Location

Loc Qty

Loc Code

CA

1

95150

1

107461

D3187-2

Manufactured

No

110

Each

1.0000

1

1

Floor Panel

DAJ
28
28

Location

Loc Qty

Loc Code

ST241A

1

~~79295~~

1

1x

A3235-020-935

Purchased

No

110

Each

211.0000

8

8

Washer - Countersunk

DAJ
28
28

Location

Loc Qty

Loc Code

ST278

211

106150

211

8x

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GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

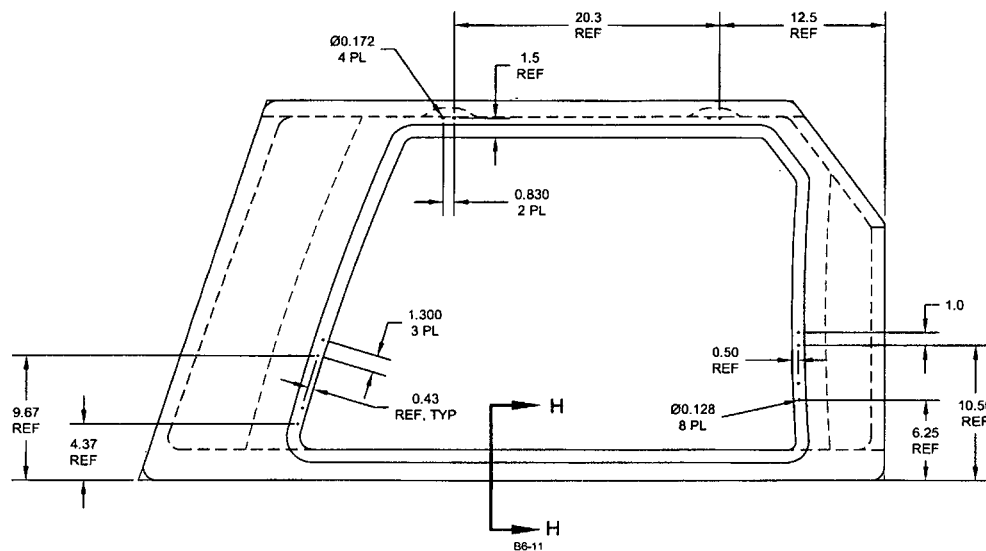
1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

- 2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A
- 8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
- 9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

RELEASED
2009-10-20
MP

REV.	DESCRIPTION	BY	DATE
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. F
CHECKED	#	D3188	SHEET 1 OF 11
MFG. APPR.	#	TITLE	SCALE
APPROVED	#	SPACEPOD BODY	NTS
DE APPR.	#	DATE 09.07.13	
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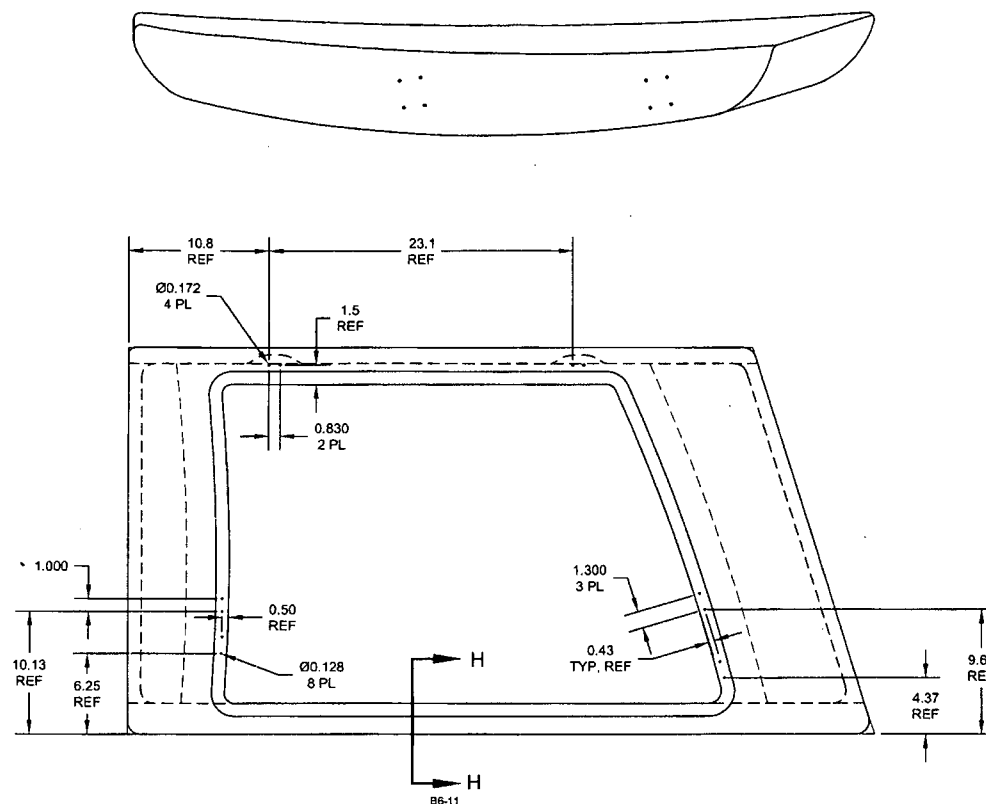
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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2009-10-20
[Signature]



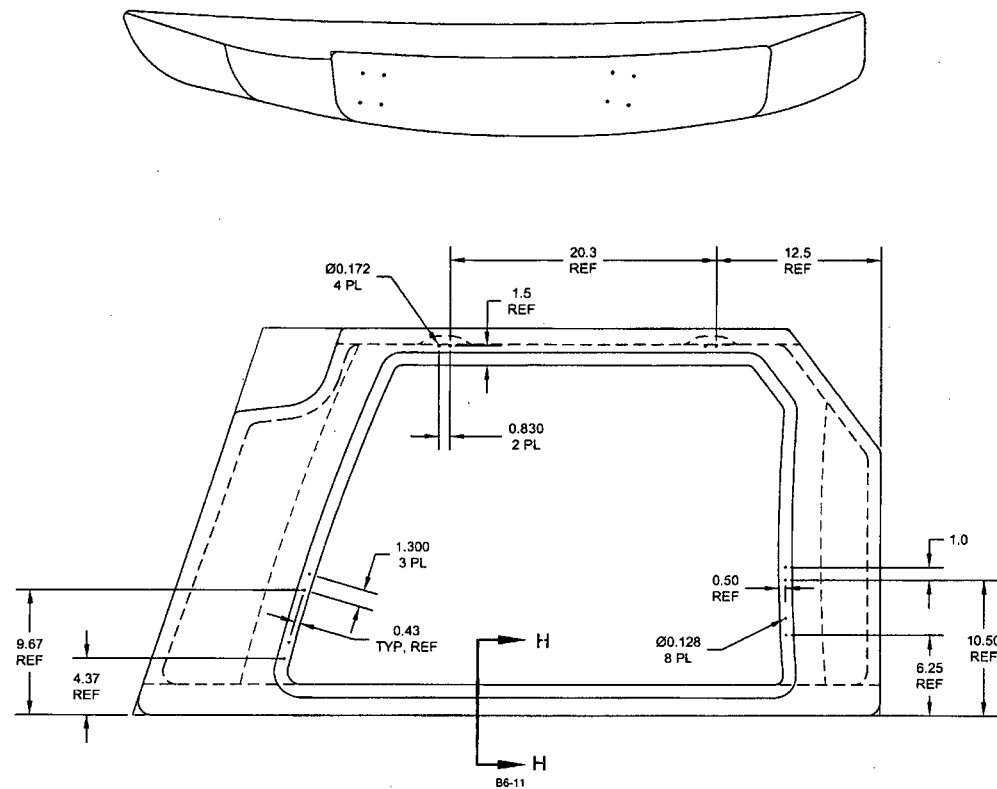
D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
NP

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 3 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
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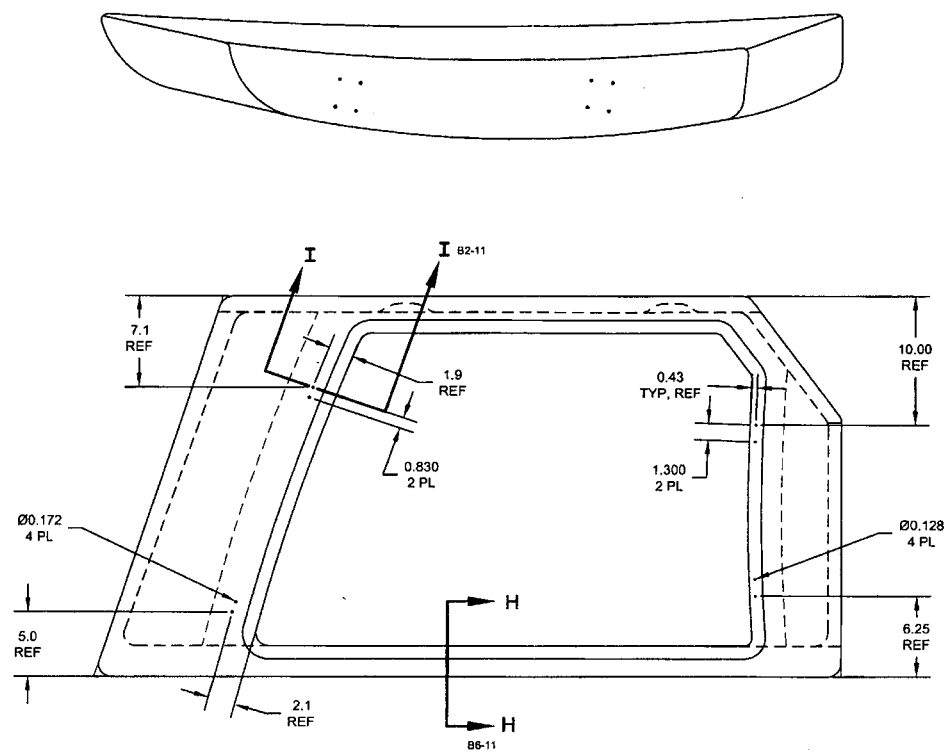
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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2009-10-20

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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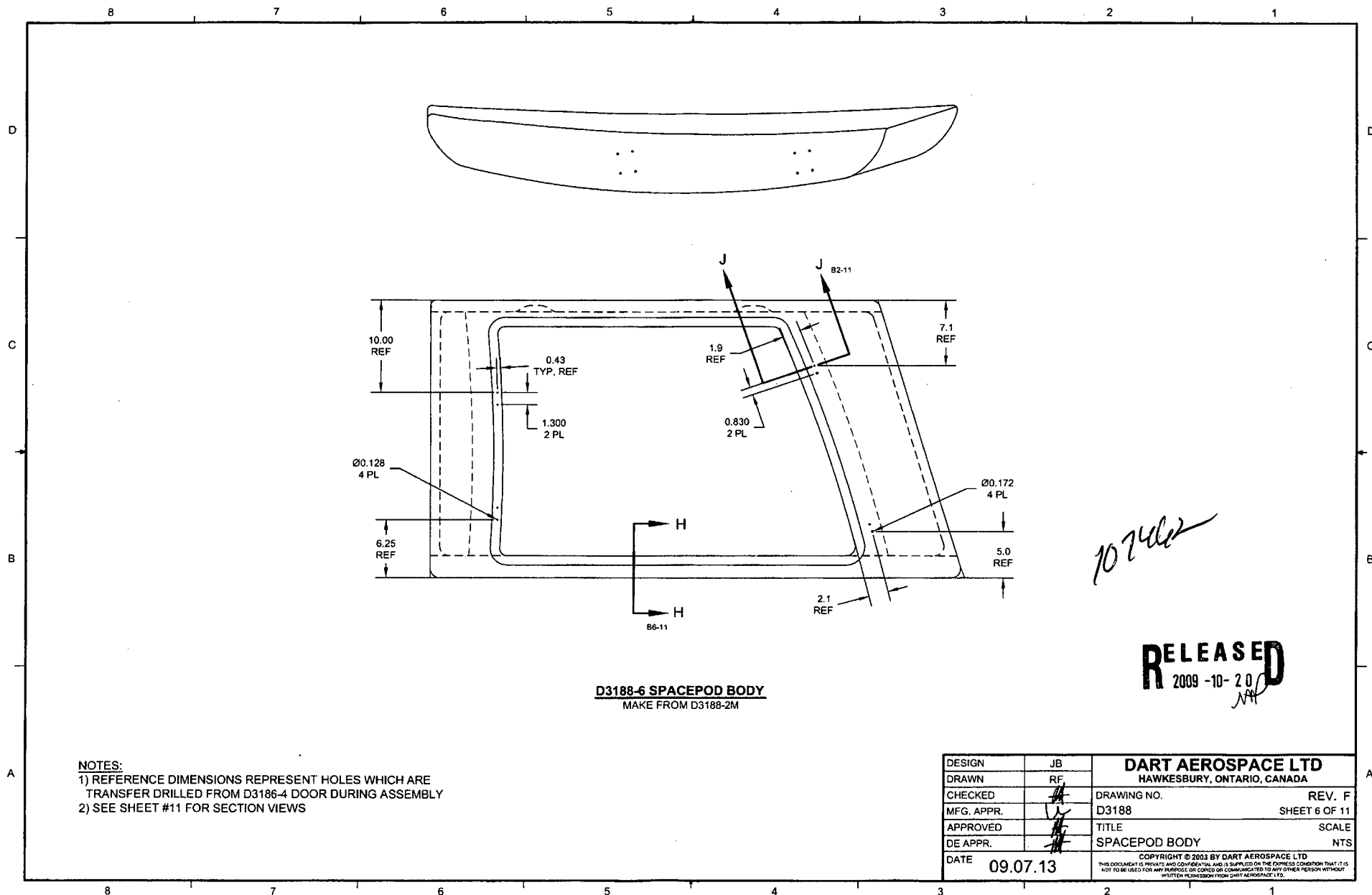
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

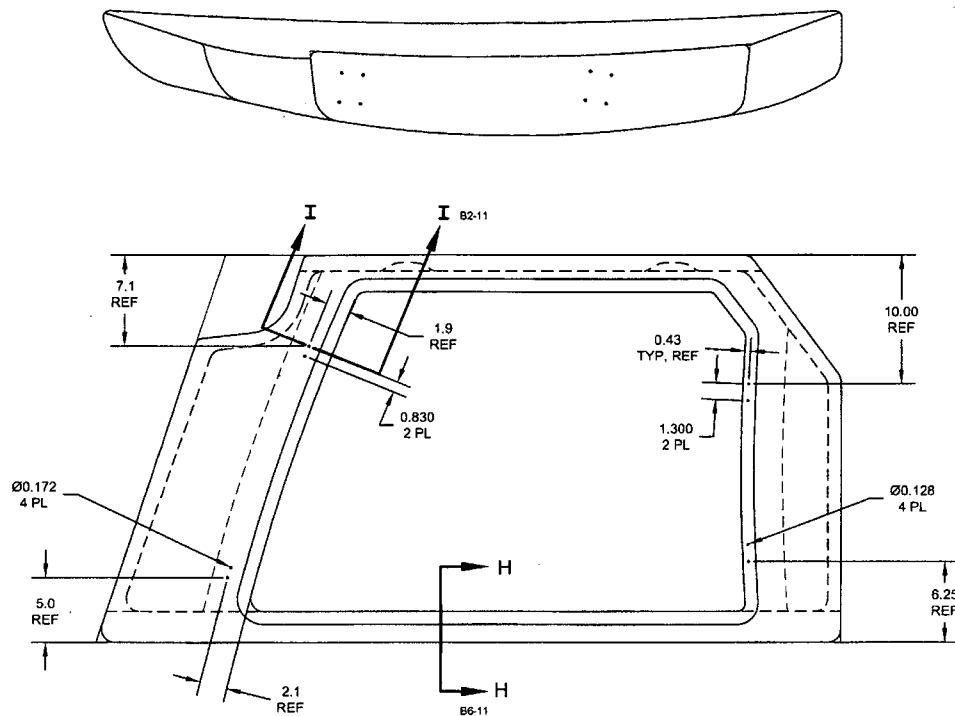
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 5 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
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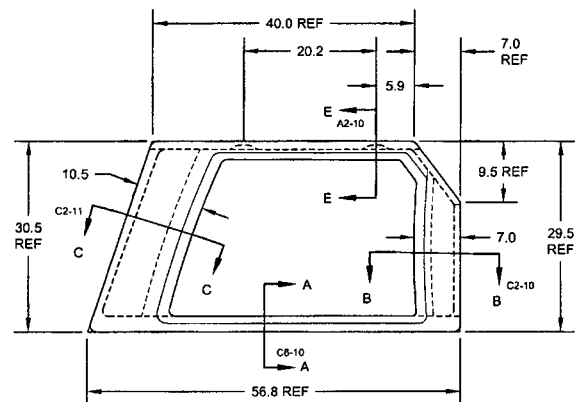
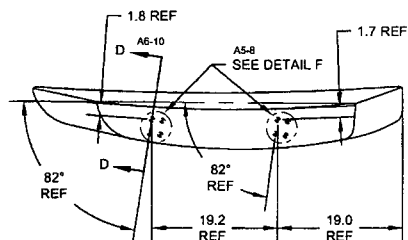
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

NOTE:

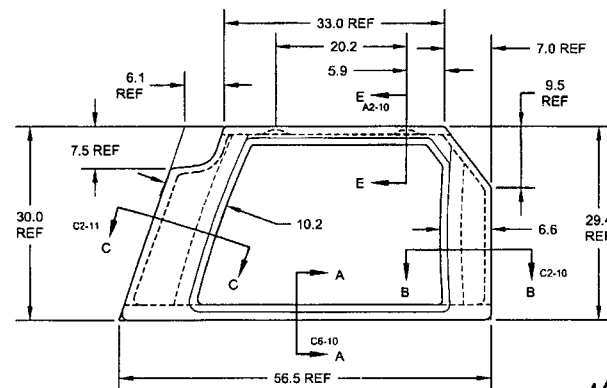
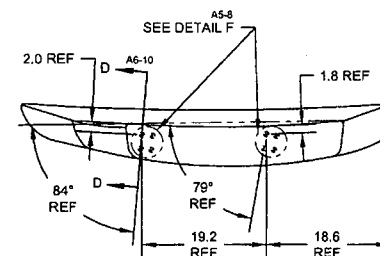
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

RELEASED
2009-10-20

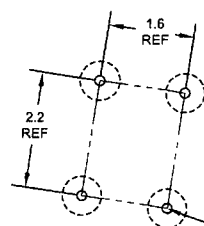
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

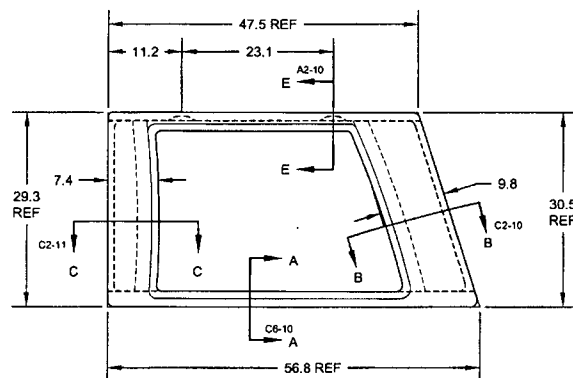
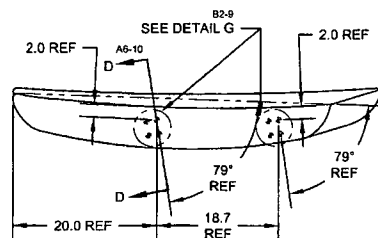
INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

D3186-1M/-3M NOTES:

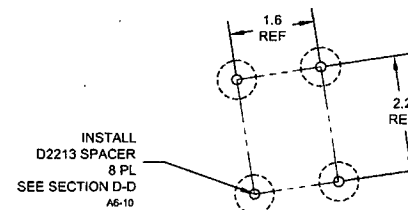
- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

RELEASED
2009-10-20

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-2M SPACEPOD BODY



DETAIL G D6-9

107462

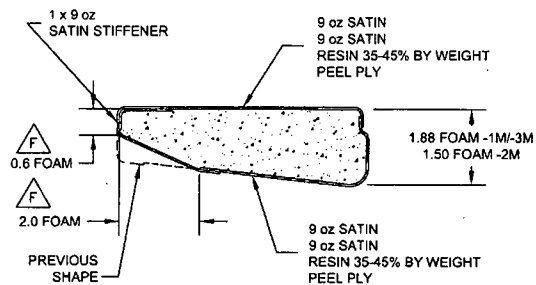
RELEASED
2009-10-20

D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

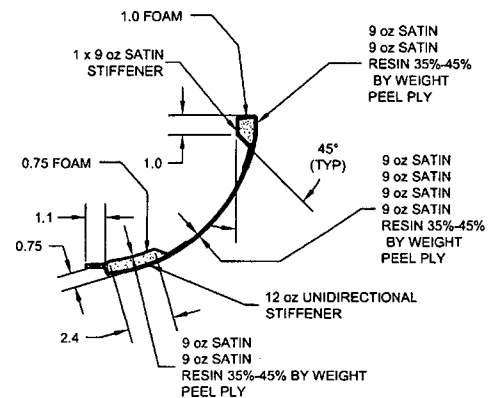
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. F
MFG. APPR.	JB	D3188	SHEET 9 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	SPACEPOD BODY	NTS
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OUTBOARD



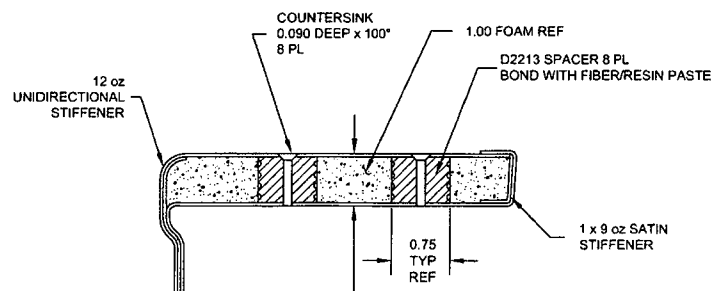
SECTION A-A
TYPICAL FLOOR SECTION

B7-8
B3-8
B6-9



SECTION B-B
SECTION C-C OPPOSITE

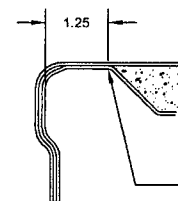
B6-8
B8-8
B4-8
B2-8
B7-9
B5-9



SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS

D3-8
D7-8
D6-9

9 oz SATIN
9 oz SATIN
18 oz CLOTH
1.00 FOAM
9 oz SATIN
9 oz SATIN
RESIN 35-45% BY WEIGHT
PEEL PLY



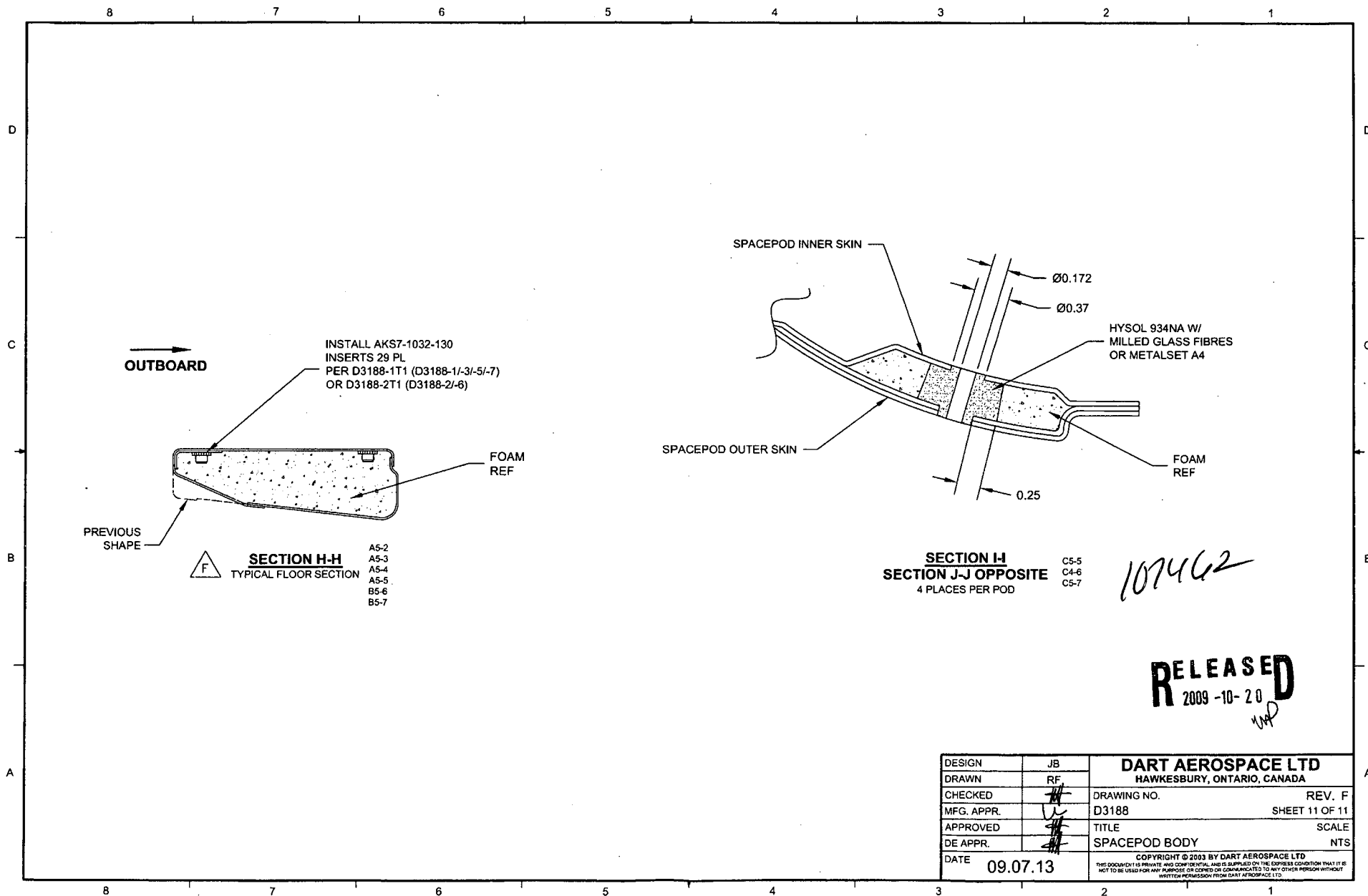
SECTION E-E
2 PLACES PER POD

C2-8
C7-8
B6-9

107462

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R 2009-10-20

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CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NTS
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B1101450

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
X	X								D350-600-241	SPACEPOD™ LH, AS350
	X								D350-600-242	SPACEPOD™ RH, AS350/355
		X							D355-600-243	SPACEPOD™ LH, AS355
1		1	X						D350-600-245	DOOR ASSEMBLY LH
	1			X					D350-600-246	DOOR ASSEMBLY RH
					X				D350-600-247	SPACEPOD™ UPGRADE KIT LH
						X			D350-600-248	SPACEPOD™ UPGRADE KIT RH
							X		D350-600-249	SPACEPOD™ UPGRADE KIT
1	1	1						X	D350-600-249	SWITCH RELOCATION KIT
2	2	2							D2174-041	WEB ASSEMBLY
							1		D2464-0360	NEOPRENE SEAL
			1	1					D2589	KEYS, KEY CHAIN
1	1	1							D2985	DECAL
1	1	1			1	1	1		D3015-3	LOCK NUT
			1		1				D3186-3	SPACEPOD DOOR, LH
				1		1			D3186-4	SPACEPOD DOOR, RH
1**		1**							D3187-1	FLOOR
	1**								D3187-2	FLOOR
1									D3188-5	SPACEPOD BODY
	1								D3188-6	SPACEPOD BODY
		1							D3188-7	SPACEPOD BODY
1	1	1			1	1	1		D3547-1	BRACKET
1	1	1			1	1	1		D3550-1	STRUT
			1	1	1	1	1		D3552-7	GAS SPRING
1	1	1			1	1	1		D3554-7	BALL STUD
8	8	8							AN3-3A	BOLT
2	2	2							AN3-10A	BOLT
8	8	8							AN3H4	BOLT
1	1	1			1	1	1		AN5-5A	BOLT
36	36	36							AN525-10R7	SCREW
8	8	8			4	4	4		AN526C832R14	SCREW
7	7	7							MS24694S67	SCREW
1	1	1			1	1	1		MS24694S69	SCREW
			2	2	2	2	2		MS27039-0811	SCREW
8	8	8			1	1	1		AN3235-020-935	WASHER
8	8	8							AN960JD10	WASHER
16	16	16			1	1	1		AN960JD10L	WASHER
			4	4	8	8	8		AN960JD8	WASHER
3	3	3			3	3	3		AN960JD516	WASHER
			2	2	2	2	2		NAS1515H3	NYLON WASHER
			2	2	6	6	6		MS21042L08	NUT
16	16	16			1	1	1		MS21042L3	NUT (or MS21042-3)
1	1	1			1	1	1		MS21042L5	NUT
16	16	16							AKS7-1032-130	INSERT
28**	28**	28**							AKS7-1032-130	INSERT
								3	M81824/1-2	SPLICE

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Revision: E

Date: 09.07.31

-241	-242	-243	-245	-246	-247	-248	-249	-449	Part Number	Description
								2	D3597-1	FEMALE SPADE CONNECTOR
								1	D3598-2-096	EXPANDABLE SLEEVE
								24	D3599-1	TIE-WRAP
								24	D3600-1	TIE-WRAP MOUNT
								24 FT	M22759/16-22-9	WIRE
			1*	1*	1*	1*			D2464-1250	NEOPRENE SEAL
1**		1**	1*		1*				D3567-1	DECAL
	1**			1*		1*			D3567-2	DECAL
			2*	2*					D2586	LATCH
			2*	2*					D2585	MOUNTING CHANNEL
			2*	2*					D2621	LATCH PLATE
			2*	2*					MS27039-1-15	SCREW
					2	2	1		MS27039-1-25	SCREW
			2*	2*	2	2	1		AN960JD10	WASHER
			2*	2*	2	2	1		MS21042L3	NUT (or MS21042-3)
			1*	1*					D2857-1	HINGE BRACKET
			1*	1*					D2857-2	HINGE BRACKET
			2*	2*					D2228	BACKING PLATE
			8*	8*	8	8	8		AN526C832R10	SCREW
			8*	8*	8	8	8		AN960JD8	WASHER
			8*	8*	8	8	8		MS21042L08	NUT
			1*	1*	1*	1*	1		D3557-1	BRACKET
			2*	2*	2*	2*	2		D2228	BACKING PLATE
			1*	1*	1*	1*	1		D3554-7	BALL STUD
			1*	1*	1*	1*	1		AN960JD516	WASHER
			1*	1*	1*	1*	1		D3015-3	LOCK NUT
			2*	2*	2*	2*	2		AN526C832R14	SCREW
			2*	2*	2*	2*	2		AN526C832R10	SCREW
			4*	4*	4*	4*	4		AN960JD8	WASHER
			4*	4*	4*	4*	4		MS21042L08	NUT
2**	2**	2**			1	1	1		D2237	STRIKER PLATE
4**	4**	4**			2	2	2		MS20426AD4-5	RIVET
2**	2**	2**			2	2	2		D3538-1	HINGE BRACKET
2**	2**	2**							D2179	HINGE BRACKET PLATE
4**	4**	4**			4	4	4		AN526C832R24	SCREW
4**	4**	4**			4	4	4		AN960JD8	WASHER
4**	4**	4**			4	4	4		MS21042L08	NUT

* PRE-INSTALLED ON D3186-3/-4 SPACEPOD™ DOOR

** PRE-INSTALLED ON D3188-5/-6/-7 SPACEPOD™

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Revision: E
Date: 09.07.31

Work Order ID 107462

107462

September-24-13 2:16:57 PM

Item ID: D350-600-242

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacepod™ Fwd Opening RH AS 350/AS 355

Start Date: 9/24/13

Start Qty: 1.00

1

Cust Item ID:


Required Date: 9/27/13

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

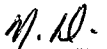
Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	F								
DSI9639	A								
IIN D350-600	Rev C								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo 	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-600-242 CHG001								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Drill holes in D3188-2 using drill jig DT8971								
	2-Open holes in D3188-2 body floor to Ø0.297" as per dwg D3188								
	3-Deburr								
	4-Install inserts in D3188-2 as per Dwg D3188.								

MLJ 13-09-26